



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D205-634-041
Job Sheet 196589



Part No: D205-634-041 **Job Qty:** 1 pcs
Part Name: Replacement Skidtube with Standard Wearplates Fits LH or RH

Part Weight: 0 lbs **Status:** New **Priority:** Medium
Job Created: 6/17/19 **Job Tracking No:**
Due Date: 7/5/19 **Created By:** Marie Lajeunesse
Type: Stock **Description:**
Note: DWG D2580 REV H SHEETS 1,2,3,8 IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30
IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD IPP Rev. O 06.02.28 Added paperwork EC IPP Rev:
07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q 10.12.01 as per chg003 DD ver:EC IPP REV:R 12.01.03
AS PER ECN11-684 VERF:EC IPP REV:S 17.12.08 REMOVE GASKET AS PER INTUITIVE INFO DD
VERF:JFS
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - Bend - 1	1 pcs		7/5/19	0.00	0.65	Skidtubes - Bend		MGA
120	Skidtubes - 2 - B4B	1 pcs		7/5/19	0.00	2.89	Skidtubes - 1 - B4B		
							Skidtubes - 2 - B4B		
							Skidtubes - 3 - B4B		MGA
							Skidtubes - 4 - B4B		
							Skidtubes - 5 - B4B		
							Skidtubes - 6 - B4B		
							Skidtubes - 7 - B4B		
130	QC 5	1 pcs		7/5/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		BE
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
140	Skidtubes - 3 - B4B	1 pcs		7/5/19	0.00	2.89	Skidtubes - 1 - B4B		
							Skidtubes - 2 - B4B		



Container No: \$198408

Part: D205-634-041
Job No: 196589
Serial No/Batch: \$198408
Revision: H
Inspector:
Exp Date:
Instructions: TC STC SH96-88 Issue 3 of 3 FAA STC SR005631

Dart Aerospace Ltd.
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CANADA
TEL.: 1 613 632-5200
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519840815

				Skidtubes - 3 - B4B	MGC
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
150 QC 10	1 pcs	7/5/19	0.00 0.00	QC 10 - 10	AUG 0 8 2019
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
160 QC 5	1 pcs	7/5/19	0.00 0.00	QC 5 - 10	AUG 0 8 2019
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
170 Handfinish - 1-1 Chemical- B4B	1 pcs	7/5/19	0.00 1.31	Handfinish - 1 - 1 - B4B	AUG 0 9 2019
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 -	

				B4B	
				Handfinish - 1 - 22 - B4B	
180 Powdercoat - 1 White Gl(A)-B4B	1 pcs	7/5/19	0.00 0.34	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	BEB 19-08-13
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
190 QC 3	1 pcs	7/5/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	ul 19-8-14
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
200 Handfinish - 4-1-Assembly-B4B	1 pcs	7/5/19	0.00 1.00	Handfinish - 4 - 1 - B4B	ul 19-8-20
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
210 QC 5	1 pcs	7/5/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	AUG 20 2019
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	

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DAS
15
9-89

DAS
81
9-89

					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
220 Packaging 3-1 - Stock - B4B	1 pcs	7/5/19	0.00 0.00	Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
225 DC - 1 - B4B	1 pcs	7/5/19	0.00 0.00	DC - 1 - B4B		
				DC - 2 - B4B	AUG 26 2019	
230 QC 21 - FG	1 pcs	7/5/19	0.00 0.00	QC 21 - FG - 21		
				QC 21 - FG - 70		
				QC 21 - FG - 53	AUG 26 2019	
Part Op 110 - Skidtubes - 1-Bend as per program D2580.C on CNC Bender and Follo 16 2-Cut tubes as per Dwg. D2580 3- scribe Descriptions: batch# in aft end of tube 120 - Skidtubes - 1- Deburr ends and remove bending marks 2- Prepare tube for welding as per QSI 004 130 - QC5- Inspect part completeness to step on W/O 140 - Skidtubes 1-Weld step D2576 as per Dwg. D2580 and QSI 004 2-Grind welds on step as per Dwg D2580 3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimention. 4-Drill holes for wearplates using DT 8217 & DT8937, 7.40" from most fwd saddle holes (ref only) Open holes to 19/64", adjust stopper not to hit web.Deburr 5-Drill pilot holes for aft cap using DT 8215Open holes to 0.208". Deburr 6-Drill pilot holes for Tow ring using DT8091, open to .640"and Deburr 150 - QC10- Inspect visual per QSI004- ground welds 160 - QC5- Inspect part completeness to step on W/O 170 - Chemical Conversion Coat per QSI005 4.1 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution. 180 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: 10:45 OVEN TEMPERATURE: 375°						

FINISH TIME: 11:00
190 - QC3- Inspect Part Finish
200 - Assemble as per dwg - 1-Install Inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 20866 Sikaflex expire date: 20-3-27 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580 3-Inspect for foreign object per QSI 024 4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive A/R Sikaflex-291 52062 Sikaflex expire date: 20-5-25 Wing Walk as per Dwg D2580 and QSI 005 4.4 Batch: 518514K
210 - QC5- Inspect part completeness to step on W/O - Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024
220 - Identify and pack for shipping as per PPPD205-634-041 Location: _____ PPP Rev: _____
225 - Document Control - Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG006
230 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2580-1	205 Bent Tube	1 pcs (1 ea)	110-Skidtubes - Bend - 1	5192517
D2576-3	Step (Machining Detail)	1 pcs (1 ea)	140-Skidtubes - 3 - B4B	5177095
D4202-1	Spacer	20 pcs (20 ea)	140-Skidtubes - 3 - B4B	5154382
ALS7-1032-130	Rivnut	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	5190821
AN3-5A	Bolt	2 Ea (2 ea)	200-Handfinish - 4-1-Assembly-B4B	5149158-1
AN3C4A	Bolt	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	5192184
D2594-1	Plug	16 pcs (16 ea)	200-Handfinish - 4-1-Assembly-B4B	5196140
D2594-3	O-Ring	16 pcs (16 ea)	200-Handfinish - 4-1-Assembly-B4B	5173297
D2855	Cap	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5194524
D3564-11	Wearplate Aft	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5196397
D3564-13	Wearpad Fwd	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5196227
D3564-5	Wearplate Center	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	X 5201529
D3564-9	Wearplate Fwd	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	X 5201657
NAS1149C0332R	Washer (AN960C10L)	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	5193136
NAS1149D0332J	Washer	2 Ea (2 ea)	200-Handfinish - 4-1-Assembly-B4B	5178378

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - Bend - 1	D2580-1	1	0	0
140-Skidtubes - 3 - B4B	D2576-3	1	36	0
	D4202-1	20	621	0
200-Handfinish - 4-1-Assembly-B4B	ALS7-1032-130	50	1,767	0
	AN3-5A	2	170	0
	AN3C4A	50	780	0
	D2594-1	16	186	0
	D2594-3	16	331	0
	D2855	1	47	0
	D3564-11	1	13	0
	D3564-13	1	8	0
	D3564-5	1	9	0
	D3564-9	1	11	0
	NAS1149C0332R	50	2,623	0
	NAS1149D0332J	2	3,102	0

Part Specifications

Specifications could not be found.

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ITEM	QTY -041	QTY -045	QTY -047	QTY -048	PART NUMBER	DESCRIPTION
1	X				D2880-041	SKIDTUBE ASSEMBLY
2		X			D2880-045	SKIDTUBE ASSEMBLY
3			X		D2880-047	SKIDTUBE ASSEMBLY
4				X	D2880-048	SKIDTUBE ASSEMBLY
20	1	1	1	1	D2880-1180	EXTRUSION
21			18	18	D2870	BUSHING
22	1	1	1	1	D2876-3	STEP
23		4			D2878	SPACER
24	18	18	8	8	D2884-1	PLUG
25	16	16	8	8	D2884-3	O-RING
26	1	1	1	1	D2886	205 WEB
27	1	1	1	1	D2885	AFT CAP
28	1	1			D2884-5	WEARSHOE
29	1	1			D2884-6	WEARSHOE
30	1	1			D2884-11	WEARSHOE
31	1	1			D2884-13	WEARSHOE
32	20	20	24	24	D4822-1	SPACER
33			1		D4405-043	WEARPLATE ASSEMBLY
34			1		D6081-1	PWD WEARPLATE
35				1	D6081-3	AFT WEARPLATE
36				1		INSERT
50	80	80			AL57-1032-130 or AN57-1032-130 or AN54-1032-130 or AELS-1032-130	
51	80	80			AN54A	BOLT
52	2	2	2	2	AN5-5A	BOLT
53			8	8	ANA-48A	BOLT
54	60	60			N481148C28352R	WASHER (AN800C10L)
55	2	2	2	2	N481148D03032J	WASHER (AN800D10L)
56			8	8	N521042-4	NUT (OR N521042L4)

EG-90-61 685961
NO. 5711

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SUBJECT TO AMENDMENT
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WORK ORDER

GENERAL NOTES:

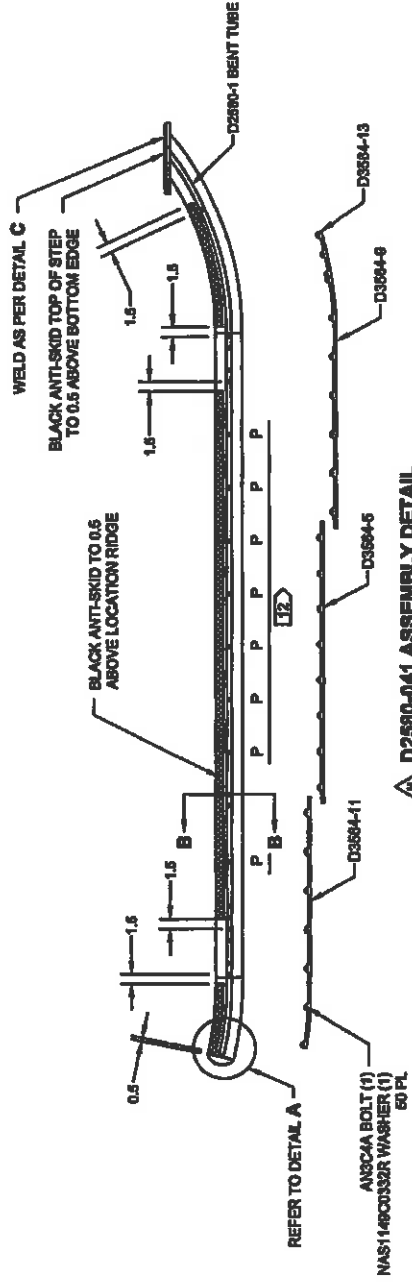
- 1) MATERIAL: WA
- 2) FINISH: CHEMICAL CONVERSION PER DART CSI 008.4.1 PRIOR TO INSERTING D2886 WEB INTO SKIDTUBE ASSEMBLY. GLOSS WHITE (REF 4.3.5.1) PER DART CSI 008.4.3
- 3) BLACK ANTI-SEED PART AS INDICATED PER DART CSI 008.4.4.
- 4) TOLERANCES: UNLESS OTHERWISE NOTED.
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK SHARP EDGES: 0.060 TO 0.070 MAX.
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: D2880-041 = 53.7 lbs
D2880-045 = 33.7 lbs
D2880-047 = 45.1 lbs
D2880-048 = 33.0 lbs
- 9) WELDING PER DART CSI 004
- 10) INSERT D2886 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO SKIDTUBE ASSEMBLY. USE NON-STRUCTURAL SKOFT-EX-241 ADHESIVE PER DART CSI 016 BEFORE BONDING. ENSURE HOLER LINE-UP.
- 11) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 80 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWED IN THE BENT PORTION OF THE TUBE.
- 12) USE DART DRILL TEMPLATE DTR517 & DTR567 ONLY FOR D2880-041/045 TO LOCATE AND DRILL 60.287 HOLES FOR WEARSHOE INSERTS. INSTALL AL57-1032-130 PER SECTIONS B.9 AND F-F (80 PLACES) AFTER FINISH. INSTALL AN54A BOLTS AND N481148C28352R WASHERS WITH SKIDTUBE ASSEMBLY.
- 13) INSERT D2884-1 PLUS CAM D2884-3 O-RING IN HOLES MARKED "P" (BOTH SIDES OF TUBE) AFTER FINISH (18 PLACES FOR D2880-041/045 AND 8 PLACES FOR D2880-047/048)
- 14) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2886 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

RELEASED
2017 JUL 05
E011-204

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	DS	07.04.05
B	AS MANUFACTURED	DS	08.02.28
C	REDRAWN, INCLUDED DEO BINA 0287	DS	08.12.03
D	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9153	PH	08.02.28
E	ADD D2880-047 (ZN C4-7) AND D2880-7 (ZN BS-9); INCLUDED DEO D2880-0-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DTR517 & DTR567 WAS TDR577-205 (ZN C4-1)	RF	11.08.21
F	INCORPORATE DEO D2880-5-1 PER PART 2216	DC	13.08.23
G	ADDED -048 -047 WEIGHT UPDATED PER DSI 0989	AJB	14.04.03
H	SHEET : PL DELETE D2886-14&13 GASKETS, WEIGHTS UPDATED ACCORDINGLY. SHEETS 2 & 4 PICTORIAL UPDATE FOR REMOVAL OF GASKETS	SAD	17.06.09

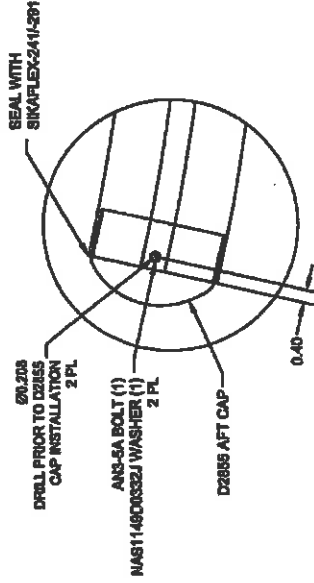
DESIGN	DS	DS	DART AEROSPACE LTD
DRAWN	SAD	SAD	HAMMERSBURY, ONTARIO, CANADA
CHECKED	DS	DS	DRAWING NO.
MFG. APPR.	DS	DS	D2880
APPROVED	DS	DS	TITLE
DE APPR.	DS	DS	205 SKIDTUBE ASSEMBLY
DATE	17.06.09	DATE	17.06.09
REV. H	SHEET 1 OF 8	REV. H	SHEET 1 OF 8
REV. H	SHEET 1 OF 8	REV. H	SHEET 1 OF 8

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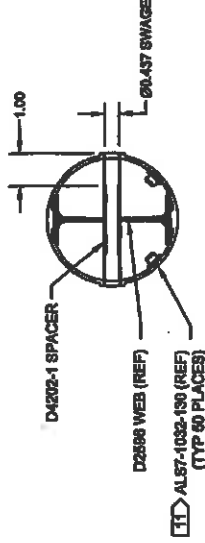


D2580-041 ASSEMBLY DETAIL

DETAIL A
SCALE 5X

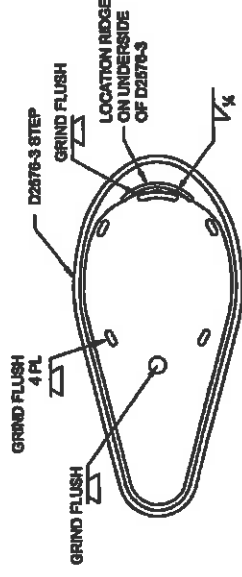


SECTION B-B
SCALE 5X



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 90.000 HOLES ONLY:
1. INSERT D4002-1 SPACER (20 PLACES)
2. SWAGE TO 90.437 X 1.00 DEEP PER Q81 002
3. TRIM / GRIND FLUSH PER Q81 002

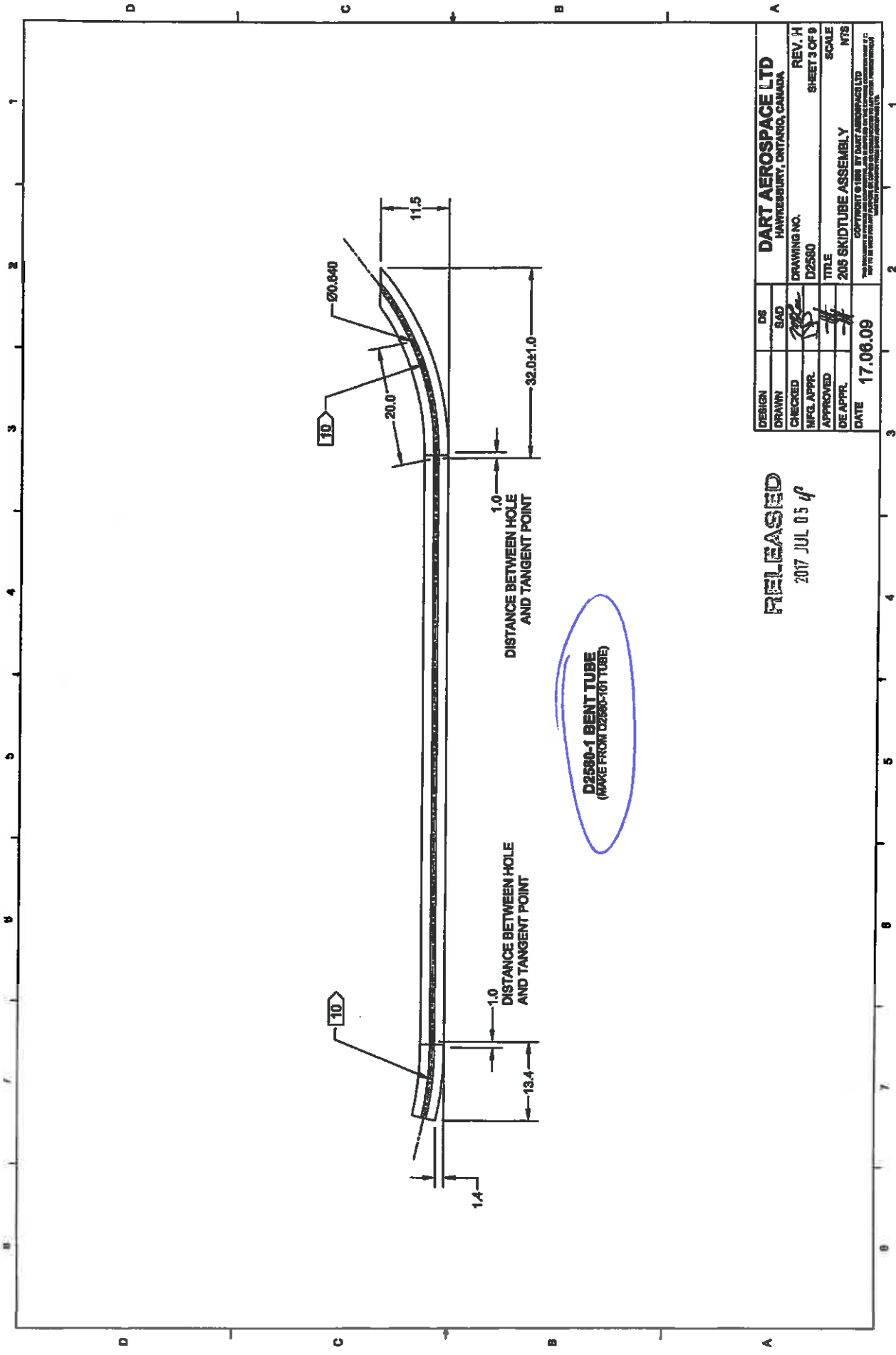
DETAIL C
SCALE 6X



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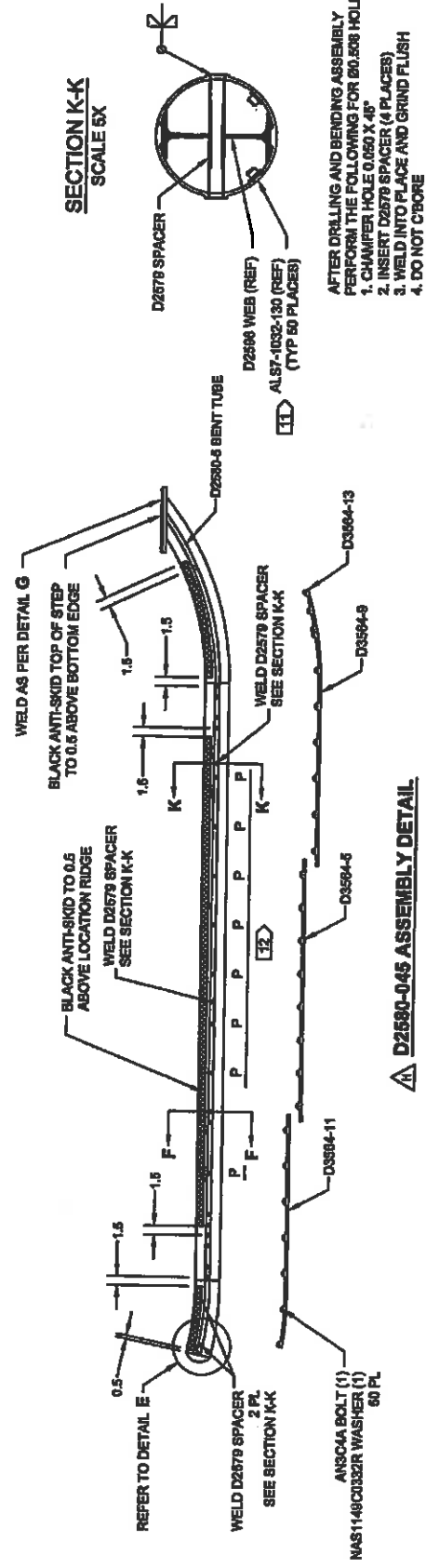
DESIGN	DS	DART AEROSPACE LTD
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG APPR		D2580
APPROVED		TITLE
DE APPR		206 SKIDTUBE ASSEMBLY
DATE	17.06.09	SCALE
		NTS

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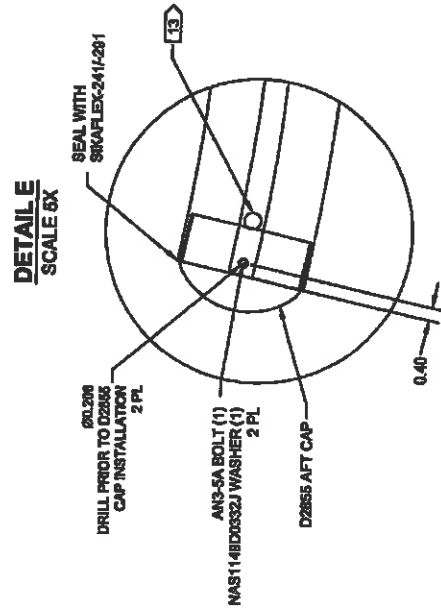
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2017 JUL 05 4p

DESIGN	DS	DART AEROSPACE LTD
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA
CHECKED	13	DRAWING NO. D2580
MPG. APPR.	13	REV. H SHEET 3 OF 9
APPROVED	13	TITLE 208 SKIDTUBE ASSEMBLY
DATE	17.06.09	SCALE NTS
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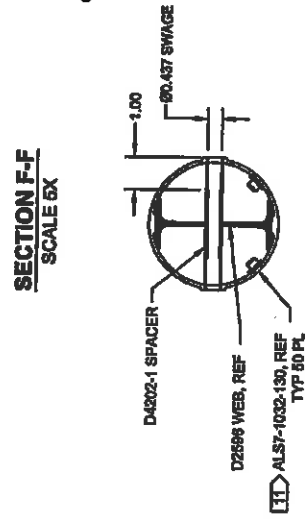


**AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:**

- 1. CHAMFER HOLE 0.050 X 45°**
- 2. INSERT D2570 SPACER (4 PLACES)**
- 3. WELD INTO PLACE AND GRIND FLUSH**
- 4. DO NOT C'BORE**

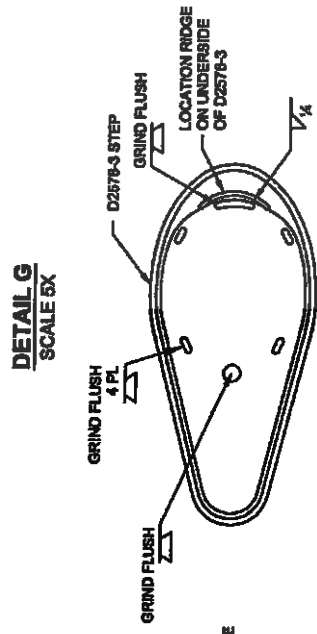


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2017 JUL 05

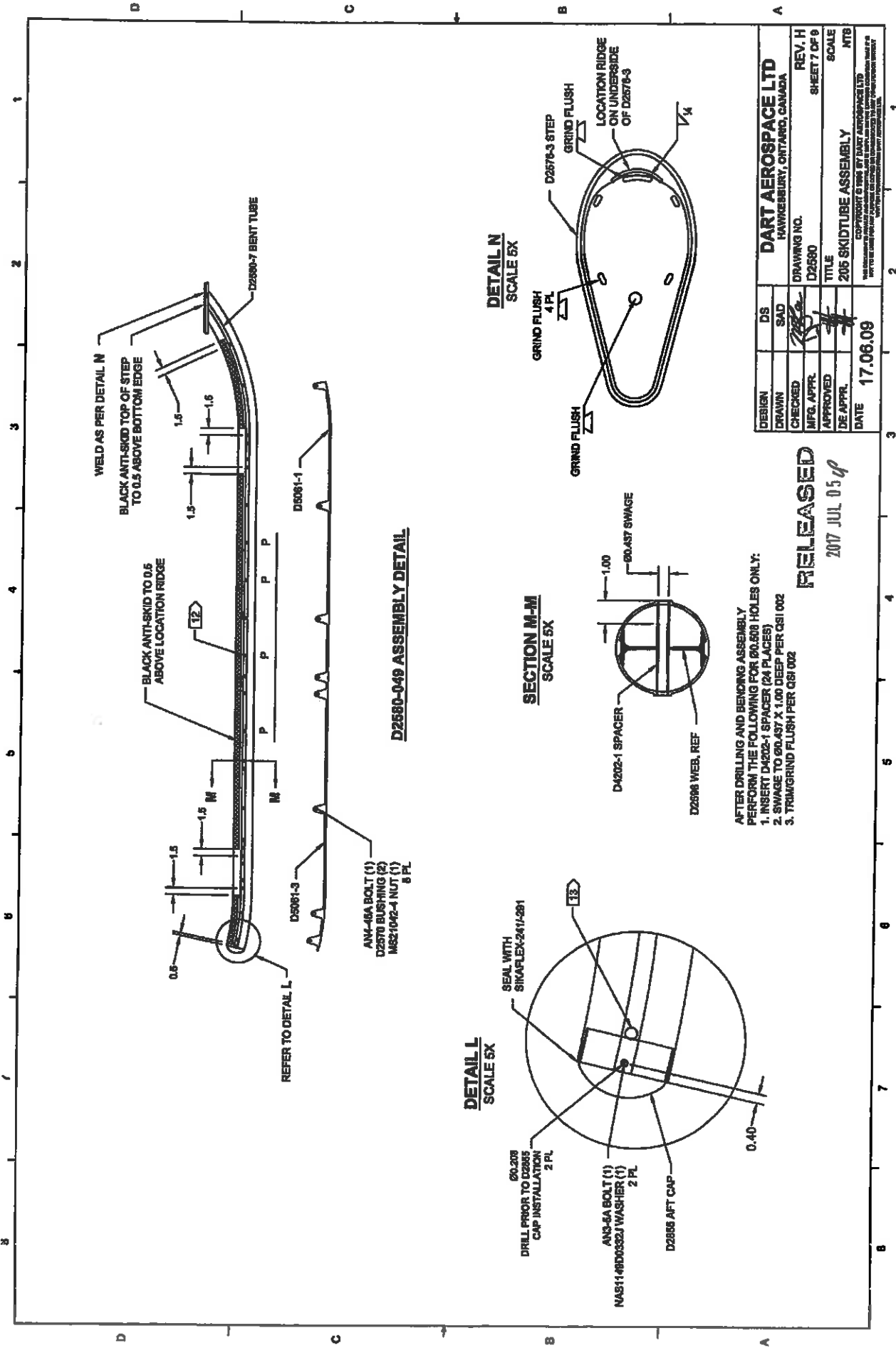


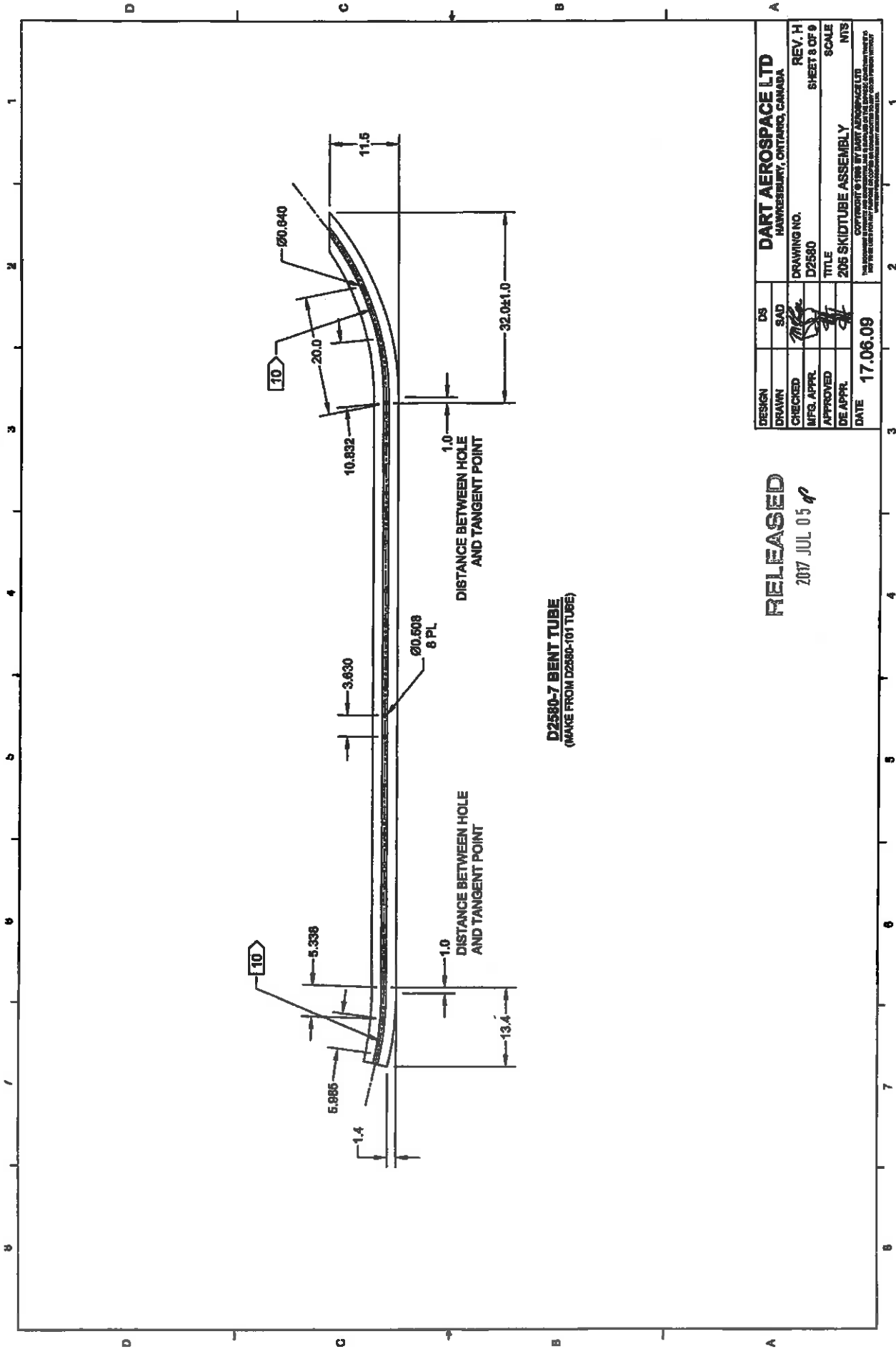
**AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:**

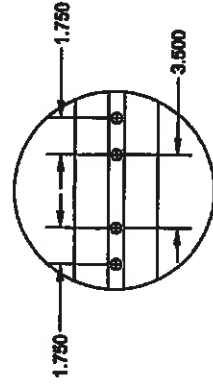
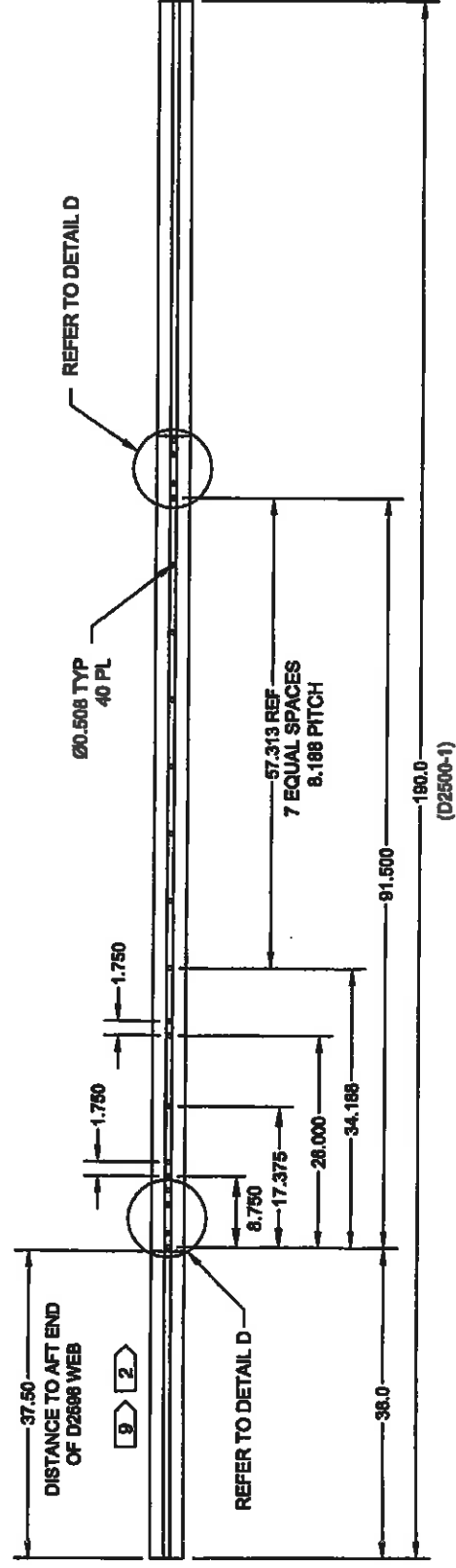
- 1. INSERT D402-1 SPACER (20 PLACES)**
- 2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002**
- 3. TRIM/GRIND FLUSH PER QSI 002**



DESIGN	DS		DART AEROSPACE LTD HAWTHORNSBURY, ONTARIO, CANADA				
DRAWN	SAD						
CHECKED							
INFO. APPR.	D2590						
APPROVED							
DATE	17.06.09	TITLE	205 SKIDTUBE ASSEMBLY	SCALE	NTS	REV. H	SHEET 4 OF 8
DE APPR.		COPYRIGHT © 1998 BY DART AEROSPACE LTD All rights reserved. No part of this publication may be reproduced, stored in a retrieval system, or transmitted in any form or by any means, electronic, mechanical, photocopying, recording, or by any information storage and retrieval system, without prior written permission from DART Aerospace Ltd.					







DETAIL D
SCALE 6X

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DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	SAD	REV. H
CHECKED		DRAWING NO. D2580
MFG. APPR.		SHEET 9 OF 9
APPROVED		TITLE 205 SKIDTUBE ASSEMBLY
DE APPR.		SCALE NTS
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D2580-101 TUBE



Job: _____		DISPOSITION			DEPARTMENT/PROCESS										
Part No. _____		Rework Scrap Use-as-is			Skid-tube Machining Large Fab		Cross tube Small Fab Finishing		Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging		Engineering Water Jet Supplier Quality				
Date : _____		Sequence #:		QTY Affected :		MRB (QS042)									
Description Work Order Deviation				Disposition											
Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors				FAULT CATEGORY											
				Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details:				Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function				Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up		Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread	
Completed By				Lead hand / Supervisor											
QC / QA Coordinator															